

9 57 C I / 36

DART AEROSPACE LTD	Work Order:	20381 A
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	15 Kits
Ref: K10008 Rev. E		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	HJ	04.02.16	15																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	HJ	04.02.23	15																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 20.00" x 24.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: 19508241 +030 114416	HJ	04.02.21	15																																																
4	MV	Inspect material for defects or damage prior to machining	HJ	04/02/23	15																																																
5	MV	Machine as per Folio D2432 and Dwg D2432	HJ	04/02/23	15																																																
6	QC2	Inspect parts as they come off the CNC machine	HJ	04/02/23	15																																																
7	MV	Deburr	HJ	04/02/23	15																																																
8	QC8 & 5	Second inspection	HJ	04/02/23	15																																																
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B18941/B19540</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B20207</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B20381</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B20089A</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B18930/B20090</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B18806</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>M14311/M13536</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B18941/B19540	12	D2274	Radius Block	B20207	2	D2432F	24" Bearpaw	B20381	6	D2438	Clamp	B20089A	12	D2529	Washer	B18930/B20090	6	D2732-050	Rubber Cushion	B18806	12	AN4-15A	Bolt	M13437	12	AN4-17A	Bolt	M14311/M13536	24	AN960JD416	Washer	M13719	12	MS21042L4	Nut (or -4)	M13276	1	Paperwork package from Step 2			CP	04/02/26	13
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10	QC4	Inspect Kit for 100% Completeness on the W/O	CP	04-03-03	13																																																
11	PK	Identify and pack for shipping as per PPP K10008 REV. E	CP	04-03-03	13																																																
12	AC	Cost / part 222.75	545	04-03-01	13																																																
13	DC	Close W/O 228.71 Inspect Level 21	HJ	04.03.05	13																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	20381
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

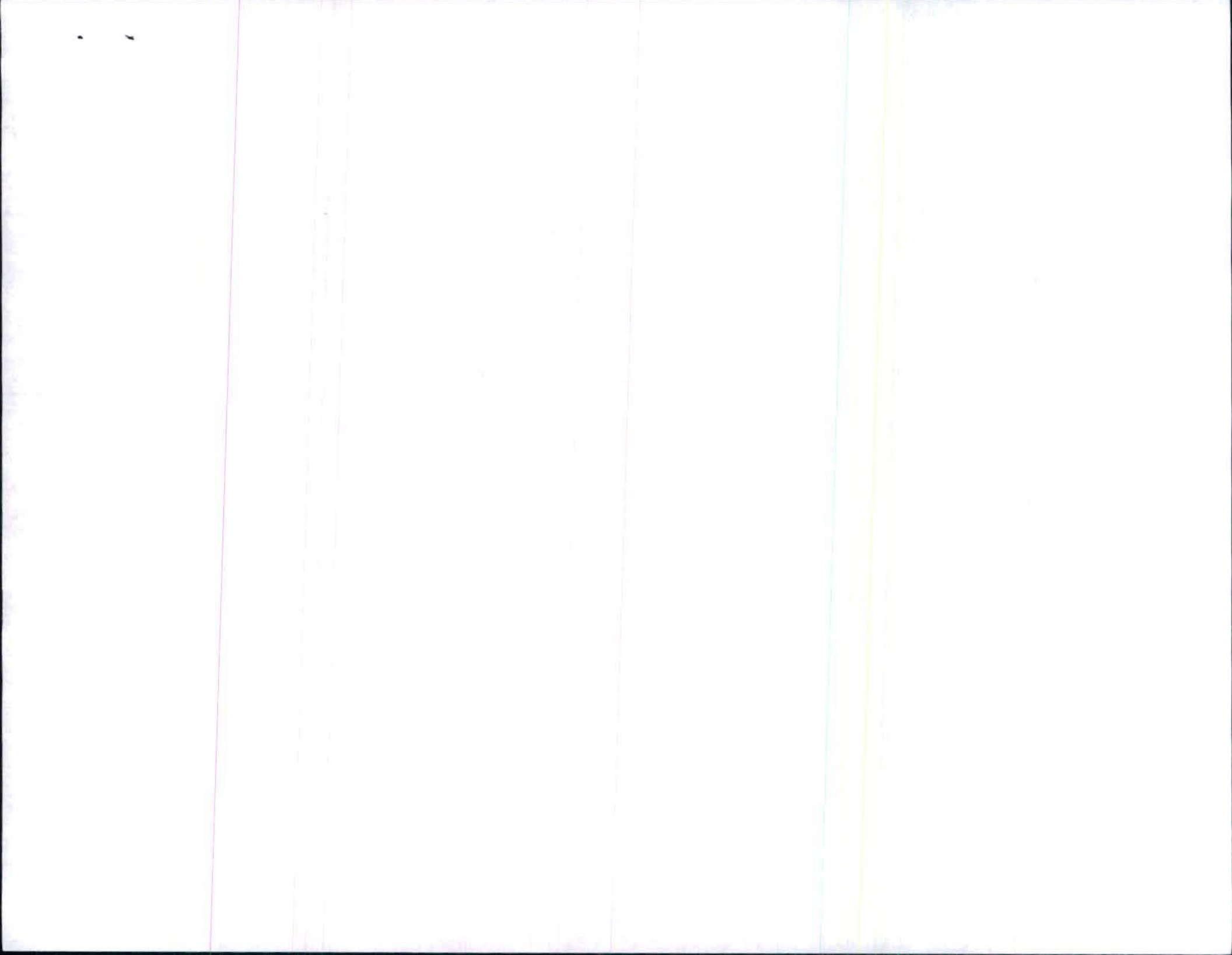
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.060	✓			
B	5.500	+/-0.030	5.515	✓			
C	0.200	+/-0.030	.202	✓			
D	0.25 x 45°	+/-0.030	.23	✓			
E	R0.250	+/-0.030	R0.250	✓			
F	0.250	+/-0.010	.247	✓			
G	0.625	+/-0.030	.615	✓			
H	0.375	+/-0.010	.376	✓			
I	0.950	+0.030/0.010	.945	✓			
J	19.000	+/-0.030	19.000	✓			
K	3.14	+/-0.030	3.155	✓			
L	3.28	+/-0.030	3.265	✓			
M	Ø0.260	+0.005/-0.000	.261	✓			
N	Ø0.93	+/-0.030	.925	✓			
O	0.30	+0.030/-0.000	.302	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.253	✓			
S	2.000	+/-0.030	2.011	✓			
T	9.000	+/-0.010	9.007	✓			
U	9.000	+/-0.010	9.003	✓			
V	0.375	+/-0.010	.383	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	04/01/09	Date:	04/01/09	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	<i>[Signature]</i>

RELEASED

04.01.15





Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 16, 2004
01:36 pm

Work Order No	: 0020381	Department Code:	
Project Name	: *K10008	Burden Flags	: NNNNNNNN
Project For	: WK409	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *K10008	Invoice Number	:
Description	: Bearpaw kit 19" x 24"	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12.5	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 02-16-04		
Est Finish Date	: 03-27-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00